

**Work Order ID 62061**

Wednesday, September 15, 2010 1:49:30 PM



Page 1

Item ID: D3294-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation -Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	Rev C								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

Dwg Rev: CProg Rev: C

2024 .080

\*grain direction on a 45 deg as per dwg\*\*

2-Deburr if necessary

IB 10-9-20

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62061**

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Page 2

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Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 6.00

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00



QC

QC8- Inspect parts - second check

0.00

Memo

Quality Control

8/10/09/20

(x6)

130

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary  
2-Bend as per Dwg D3294  
(Ensure angle is correct)

SB 10/09/29

(6)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

Quality Control

8/10/09/29

(x6)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

**Abstract**

Page 3

**Accept**

**Setup Start**[illegible]

**Stop**

**Cust Item ID:**[illegible]

**Customer:**

Run Start

**Abstract**

**Stop**

[illegible]

## Insp. Stamp

16K 10-9-30



0.00

10-9-30

0.00

**Abstract**

0.00

6B

0.00

44-38861-1  
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 44-38861-99  
 44-38861-100

0.00

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

5/10/04 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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Page 5

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Revision ID:

Stop

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Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: 212

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PC 10/10/05 (6)10/10/05MF  
10-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 15, 2010 1:49:34 PM

Page 1

Work Order ID: 62061

Parent Item: D3294-1

Parent Item Name: Bracket



Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP ☐ A ☐ 04.08.24 ☐ New issue ☐ KJ/JLM ☐  
 IPP Rev:B Now On Waterjet 07-03-26 JLM  
 IPP Rev:C 08-07-16 Redesign part DD verified by:EC  
 IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	112.6000	1.8	11.36842			



2024-T3 .080 sheet

Location	Loc Qty	Loc Code
MAT22	112.6	
104921	2	
105411	7	
112331	3	
113796	9.7	
114025	90.9	

1810-9-20

6

D3294-5



Doubler

Manufactured No

170 Each 30.0000

Location	Loc Qty	Loc Code
WA	30	
55331	30	

6

9/10/10/04

MS20470AD4-5



Rivet, Universal Head

Purchased No

170 Each 1,073.000

Location	Loc Qty	Loc Code
ST309	1008	
114761	1008	
ST319	65	
111916	65	

15 90

9/10/10/04

90

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62001
<b>Description:</b> Bracket Assembly		<b>Part Number:</b>	D3294-1
<b>Inspection Dwg:</b> D3294 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	X		V 1B09	
Ø0.141	+0.005/-0.001	.142	X		V	
6.708	+/-0.010	6.702	X		V	
1.118	+/-0.010	1.111	X		V	
5.590	+/-0.010	5.590	X		V	
1.118	+/-0.010	1.111	X		V	
13.563	+/-0.010	13.563	X		V H301	
1.043	+/-0.010	1.042	X		V	
0.625	+/-0.010	.624	X		V	
0.325	+/-0.010	.321	X		V	
0.300	+/-0.010	.298	X		V	
0.400	+/-0.010	.397	X		V	
6.000	+/-0.010	6.000	X		V	
1.000	+/-0.010	1.002	X		V	
17.124	+/-0.010	17.125	X		T	
16.13	+/-0.030	16.13	X		T	
7.27	+/-0.030	7.27	X		T	
11.97	+/-0.030	11.97	V		T	
8.37	+/-0.030	8.372	X		V	
20.05	+/-0.030	20.05	X		T	
12.98	+/-0.030	12.98	X		T	
14.59	+/-0.030	14.59	X		T	
11.66	+/-0.030	11.66	X		T	
0.080	+/-0.010	.079	X		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-9-20	<b>Date:</b> 10/09/20	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

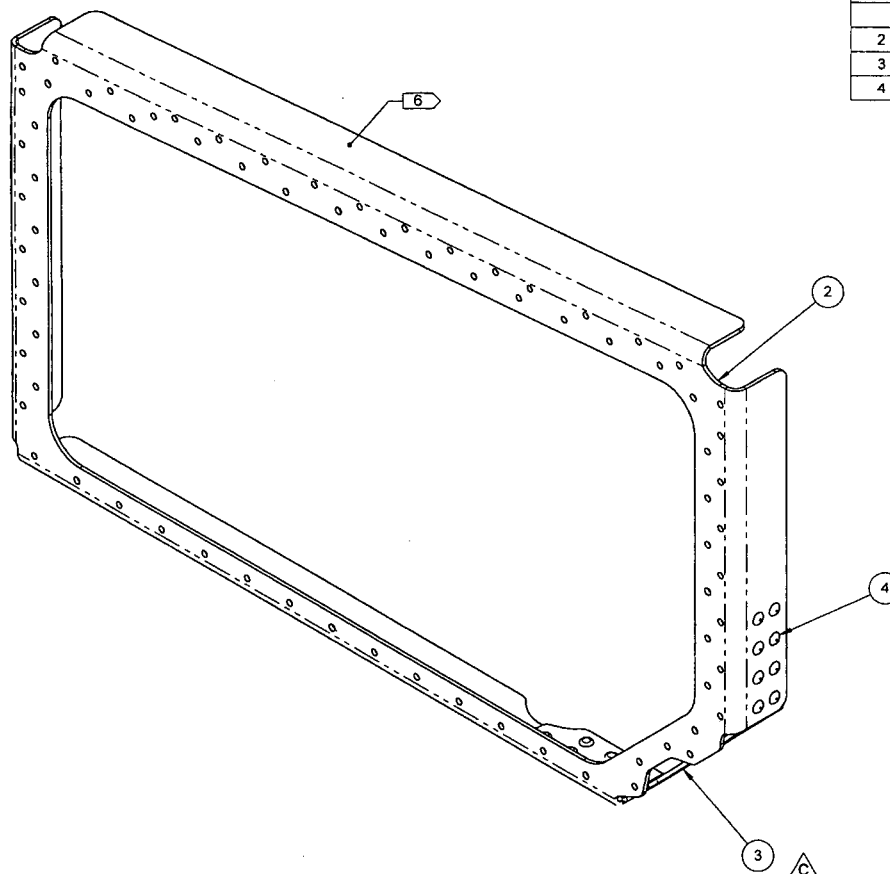
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. C-2061  
BS10-7-15

**RELEASED**  
09/03/24

REV.	DESCRIPTION	BY	DATE
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1, C3-2. CHANGE GRAIN DIRECTION. ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
DESIGN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3294</b> TITLE <b>BRACKET</b> COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24	REV. C	SHEET 1 OF 6
		SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





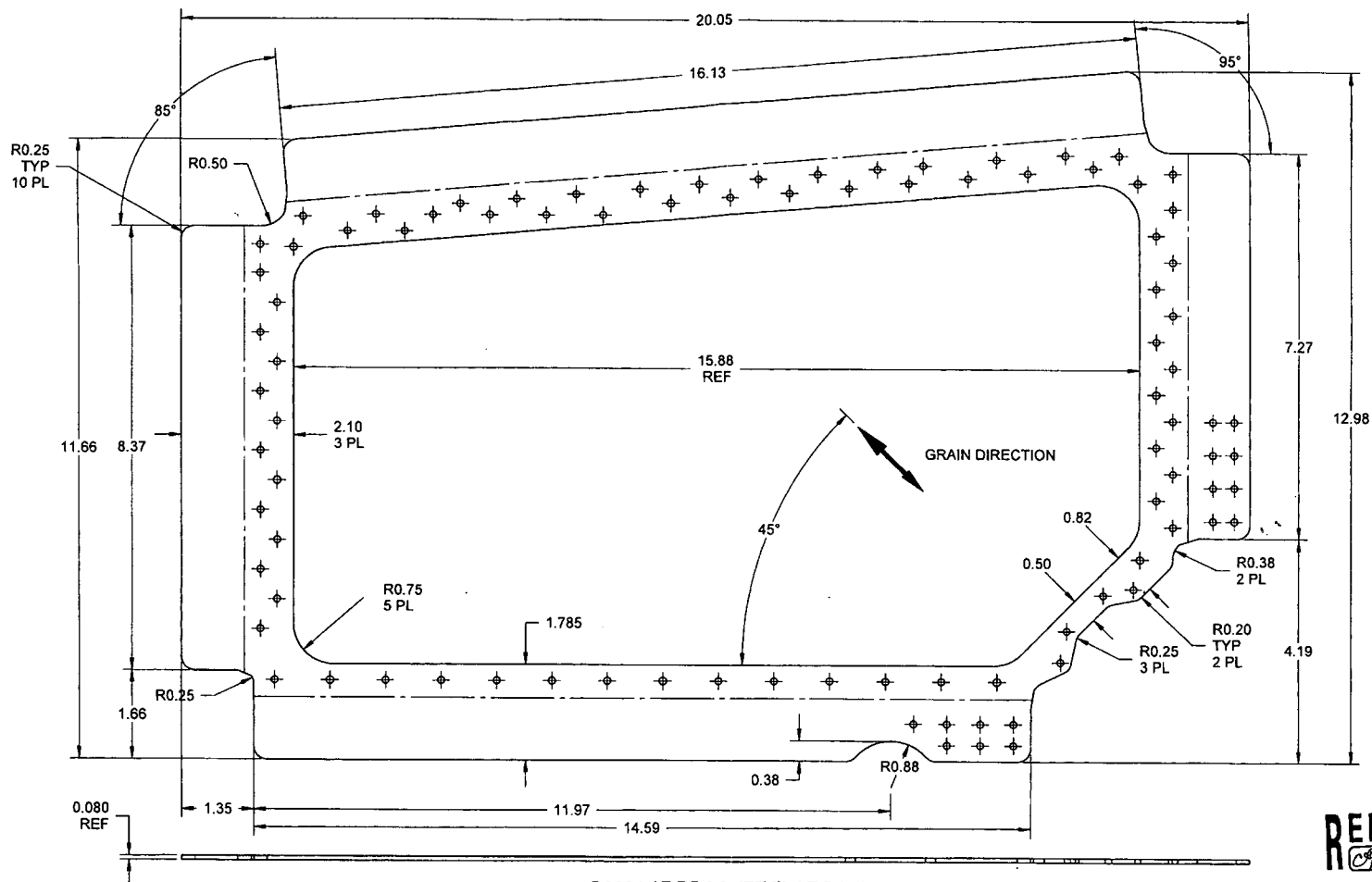
W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



**D3294-3F BRACKET FLAT PATTERN**

**RELEASED**  
09/04/07

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

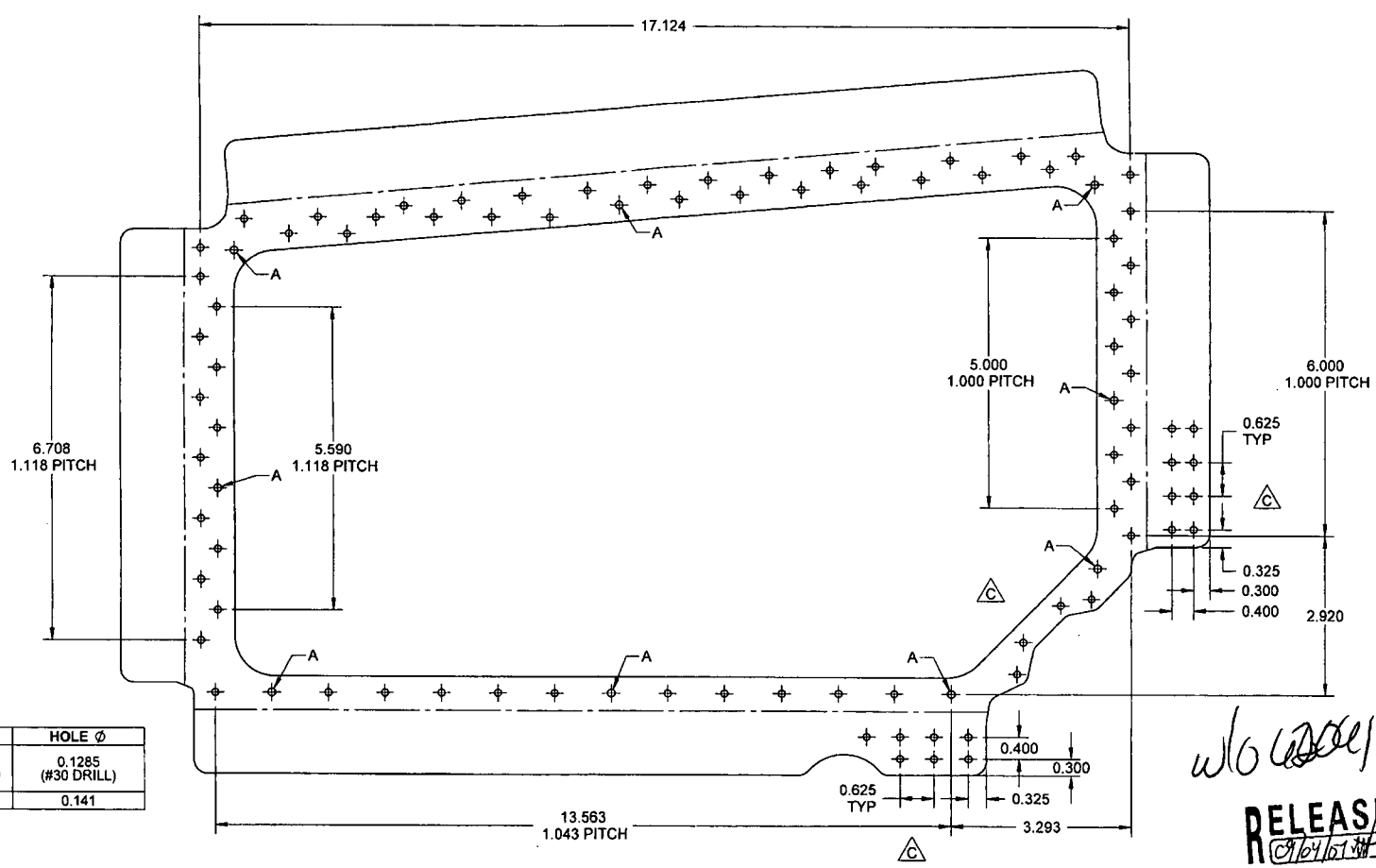
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D  
C  
B  
A



LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

**D3294-3F BRACKET FLAT PATTERN**  
SUPPLEMENTAL

*w/o [signature]*  
**RELEASED**  
*09/04/01*

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D3294</b>
MFG. APPR.		REV. C
APPROVED		TITLE <b>BRACKET</b>
DE APPR.		SCALE <b>NTS</b>
DATE	<b>09.03.24</b>	COPYRIGHT © 2004 BY DART AEROSPACE LTD

8 7 6 5 4 3 2 1

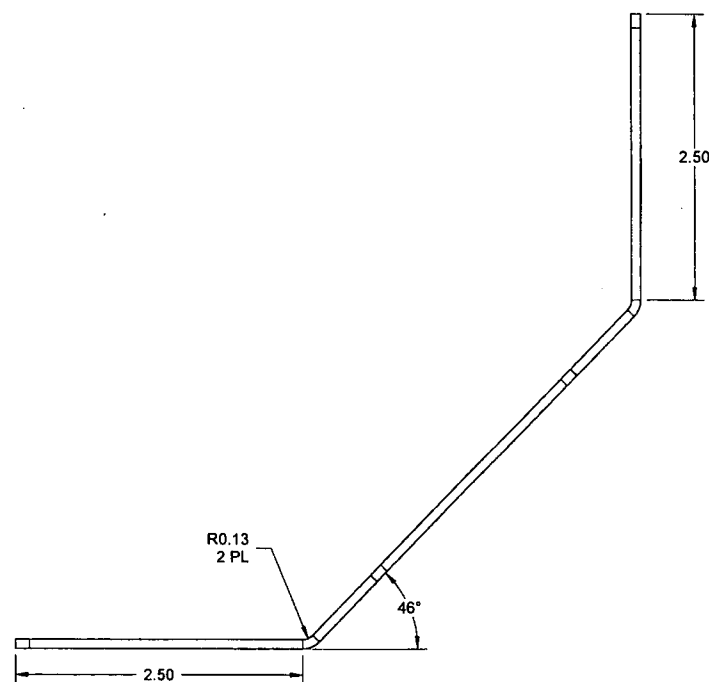
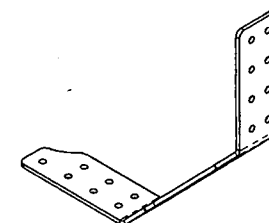
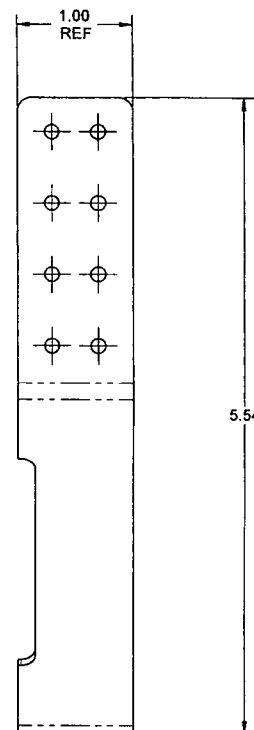
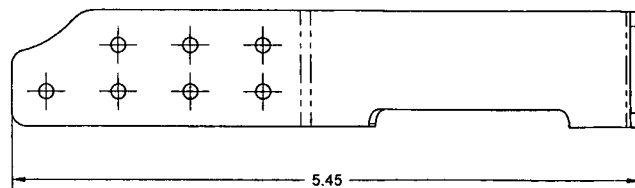
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**NOTE:** Date & initial all entries



**D3294-5 DOUBLER**  
MADE FROM D3294-5F



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

*w/b 62061*

**RELEASED**  
*9/10/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries